Work Order ID 63271

Wednesday, October 27, 2010 9:06:52 AM

Item ID: D212-725-1-153F **Accept**

Revision ID:

Item Name: Support Angle Oil Cooler

Setup Start / Stop

Start Date: 10/27/2010 **Start Qty:** 2.00

Required Date: 11/30/2010 **Req'd Qty:** 2.00

Cust Item ID:

Customer:

Reference:

Approvals: **Process Plan:** [signature] **Date:** 10 10 27 **Tooling:** ______ **Date:** ______

QC: ______ **Date:** ______ **SPC (Y/N):** ______ **Date:** ______

Run Start / Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr: D212-725-1	**Revision Nbr:** E								
100		0.00							
Waterjet FLOW CNC Waterjet 2024 .040	**Memo** 1-Cut as per Dwg Dwg Rev: E Prog Rev: E 2-Deburr if necessary	0.00				B 10-10-27			
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
QC Quality Control	**Memo**	0.00				HB 10-10-27			

(2)

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W/O:	WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ **PAR #:** _______ **Fault Category:** _________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

Resolution: ____________________ **Disposition:** ____________________ **QA: N/C Closed:** __________ **Date:** _________

NCR:	WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 63271

Wednesday, October 27, 2010 9:06:52 AM

Item ID: D212-725-1-153F **Accept**

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Stop

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Customer:

Reference:

Run Start

Stop

Approvals: **Process Plan:** ______ **Date:** ______ **Tooling:** ______ **Date:** ______

QC: ______ **Date:** ______ **SPC (Y/N):** ______ **Date:** ______

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 QC Quality Control	QC8- Inspect parts - second check **Memo**	0.00 0.00 S 10/10/28				x2			
130 Brake NC Brake NC	Bend as per dwg **Memo**	0.00 0.00 SD 10/10/29				2			
140 QC Quality Control	QC5- Inspect part completeness to step on W/O **Memo**	0.00 0.00 S 10/10/29				x2			

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ PAR #: _______ Fault Category: __________________ NCR: Yes No DQA: _____ Date: _________

Resolution: ____________________ Disposition: ____________________ QA: N/C Closed: __________ Date: _________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 63271

Wednesday, October 27, 2010 9:06:52 AM

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Revision ID:

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Start Date: 10/27/2010 **Start Qty:** 2.00

Required Date: 11/30/2010 **Req'd Qty:** 2.00

Cust Item ID:

Customer:

Reference:

Run Start / Stop

Approvals: **Process Plan:** ____ **Date:** ____ **Tooling:** ____ **Date:** ____

QC: ____ **Date:** ____ **SPC (Y/N):** ____ **Date:** ____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 **Memo**	0.00 0.00	27 [signature]	10/6/24		2	[signature]		
160 QC Quality Control	QC3- Inspect Part Finish **Memo**	0.00 0.00				[signature] 11/1/29 (2)			
170 Packaging Packaging	Identify as per dwg & Stock Location: 385 **Memo**	0.00 0.00				[signature] 11/1/29 (2)			

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ **PAR #:** _______ **Fault Category:** __________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

Resolution: ____________________ **Disposition:** ____________________ **QA: N/C Closed:** __________ **Date:** _________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 63271

Wednesday, October 27, 2010 9:06:52 AM

Item ID: D212-725-1-153F **Accept** **Setup** **Start**

Revision ID:

Item Name: Support Angle Oil Cooler **Stop**

Start Date: 10/27/2010 **Start Qty:** 2.00 **Cust Item ID:**

Required Date: 11/30/2010 **Req'd Qty:** 2.00 **Customer:**

Reference:

Run **Start**

Approvals: **Process Plan:** ____________ **Date:** ________ **Tooling:** ________ **Date:** ________

QC: ______________ **Date:** ________ **SPC (Y/N):** ________ **Date:** ________ **Stop**

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	QC21- Final Inspection - Work Order Release	0.00					10	10/10/29	
QC Quality Control	**Memo**	0.00							

CL 10/10/29

Dart Aerospace Ltd

W/O:	WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ________ **PAR #:** ________ **Fault Category:** ________ **NCR:** Yes No **DQA:** ________ **Date:** ________

Resolution: ________ **Disposition:** ________ **QA: N/C Closed:** ________ **Date:** ________

NCR:	WORK ORDER NON-CONFORMANCE (NCR)							
			Corrective Action Section B					
DATE	STEP	Description of NC Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector

NOTE: Date & initial all entries

H:\fFORMS\Quality Assurance\approved QA\NCRWO RevE

Picklist Print

Wednesday, October 27, 2010 9:07:00 AM

Work Order ID: 63271

Parent Item: D212-725-1-153F

Parent Item Name: Support Angle Oil Cooler

Start Date: 10/27/2010 **Required Date:** 11/30/2010

Start Qty: 2.00 **Required Qty:** 2.00

Comments: IPP Rev:A 10.07.19 new issue DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.040 2024-T3 .040 sheet		Purchased	No			100	sf	315.6400	0.2416	0.508632		1810-10-27	

Location		Loc Qty	Loc Code	
MAT		78.1		
	114415	78.1		
MAT22		237.54		
	110305	21.93		
	111786	13.76		111786
	112291	28.25		
	112331	52		
	113162	121.6		

2

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ **PAR #:** _______ **Fault Category:** _________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

Resolution: ___________________ **Disposition:** ____________________ **QA: N/C Closed:** __________ **Date:** _________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
			Corrective Action Section B					
DATE	STEP	Description of NC Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	63371
Description: Support Angle oil Cooler	Part Number:	D212-725-1-153F
Inspection Dwg: Rev: E		Page 1 of 1

D212-725-1-153

FIRST ARTICLE INSPECTION CHECKLIST

[X] First Article [X] Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.648	+/- .010	1.648	✓		V HB02	
.60	+/- .030	.60	✓		V	
1.00	+/- .030	1.00	✓		V	
.65	+/- .030	.65	✓		V	
2.00	+/- .030	1.990	✓		V	
17.40	+/- .030	17.375	✓		V	
.040	+/- .010	.041	✓		V	

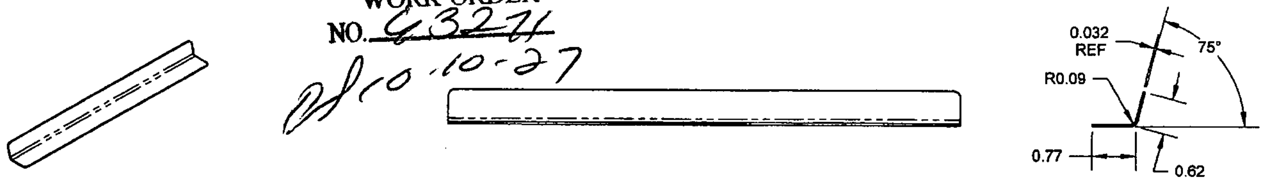
Measured by:	HB
Date:	10-10-07

Audited by:	S
Date:	10/10/25

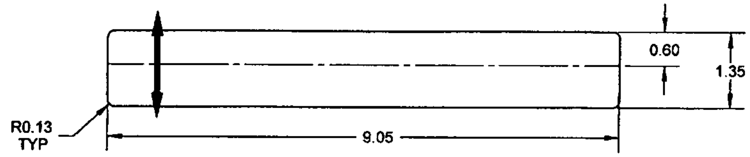
Prototype Approval:	
Date:	

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 63271
2010-10-27

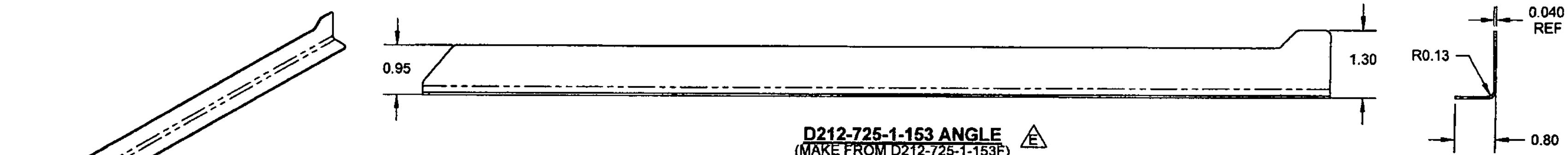


D212-725-1-155 ANGLE
(MAKE FROM D212-725-1-155F)

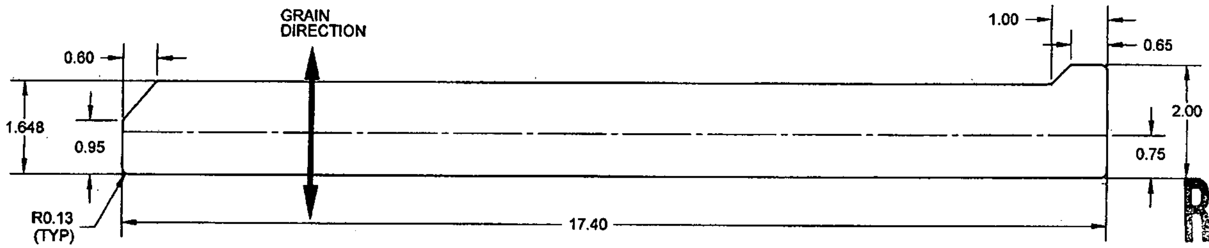


D212-725-1-155F FLAT PATTERN

D212-725-1-155 NOTES:
1) MATERIAL: 2024-T3 SHEET 0.032 THICK PER QQ-A-250/4 OR AMS 4037 (REF. DART SPEC. M2024T3S.032)
2) FINISH: ACID ETCH, ALODINE 1200 OR 1201 PER MIL-C-5541 AND/OR PRIME PER AIRCRAFT MAINTENANCE MANUAL
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER
7) WEIGHT: N/A



D212-725-1-153 ANGLE (E)
(MAKE FROM D212-725-1-153F)



(E) **D212-725-1-153F FLAT PATTERN**

RELEASED
2009-10-28

D212-725-1-153 NOTES:
1) MATERIAL: 2024-T3 SHEET 0.040 THICK PER QQ-A-250/4 OR AMS 4037 (REF. DART SPEC. M2024T3S.040)
2) FINISH: ACID ETCH, ALODINE 1200 OR 1201 PER MIL-C-5541 AND/OR PRIME PER AIRCRAFT MAINTENANCE MANUAL
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER
7) WEIGHT: N/A

DESIGN	RF	**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA
DRAWN	RF	
CHECKED	DS	DRAWING NO. D212-725-1 REV. E SHEET 52 OF 82
MFG. APPR.	N/A	
APPROVED	[illegible]	TITLE 212S DETAIL PARTS SCALE NTS
DE APPR.	[illegible]	
DATE	08.09.17	

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ PAR #: _______ Fault Category: ________________ NCR: Yes No DQA: _____ Date: _________

Resolution: ___________________ Disposition: ___________________ QA: N/C Closed: _________ Date: _________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries